

Date: Monday, 26/05/2008 12:57:42 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CLAMP	
Job Number	: 39489			Part Number	: D3758041	
Estimate Number	: 13263			Drawing Number	: D3758 PROTO	
P.O. Number	:			Project Number	: N/A	
This Issue	: 26/05/2008	S.O. No.	:	Drawing Revision	: PROTO	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: R & D SM/MED FAB	Due Date	: 28/05/2008	
Previous Run	: 38603			Qty:	2	Um: Each
Written By	:					
Checked & Approved By	: <u>LL</u>					
Comment	: Est Rev:A new issue 08-05-26 DD verified by:EC					

Additional Product

Job Number:

**PROTOTYPE**

Seq. #:	Machine Or Operation:	Description :	
1.0	M304S22GA	304/316 .032 Sheet	
Comment: Qty.: 0.0273 sf(s)/Unit Total : 0.0546 sf(s) 304/316 .032 Sheet Batch: <u>102159</u> <u>IB 8-5-26</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3758 Dwg Rev: <u>PFEL</u> <u>IB 8-5-26</u> Prog Rev: <u>PFEL</u> <u>IB 8-5-26</u> (4)			
2-Deburr if necessary <u>IB 8-5-26</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<u>IB 8-5-26</u>			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK ENGINEERING APPROVAL	
<u>0805.26 (4)</u> CP <u>08.05.26 (4)</u>			
Comment: SECOND CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
<u>IB 08/05/23 (4)</u>			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr any rough edges 2- Form as per Dwg D3758			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 39489

Part Number: D3758041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



0805.28(4)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

SB 08/06/05(4)

8.0 D2182B~~000~~

Rubber Cushion



CUSHIONS
ARE
REPRESENTATIVE
CP 08.06.05

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Cushion

4.000

batch: B21185

FF 08-06-05(4)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble rubber cushion as per dwg D3758

FF 08-06-05(4)

10.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

IP 08.06.05(4)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Chris P



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

00079A

IP 08.06.05(4)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08.06.09 Preliminary



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-07-03

Job Completion



PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-778

Job #: 00079

Date: 08.05.26

Product Name: Comfort Seat

Requested By: CP

Design Manager Approval:

8

7

6

5

4

3

2

1

QTY	P/N	DESCRIPTION
-041	X D3758-041	CLAMP
1	D3758-1	CLAMP
1	D2182B028	RUBBER CUSHION

D

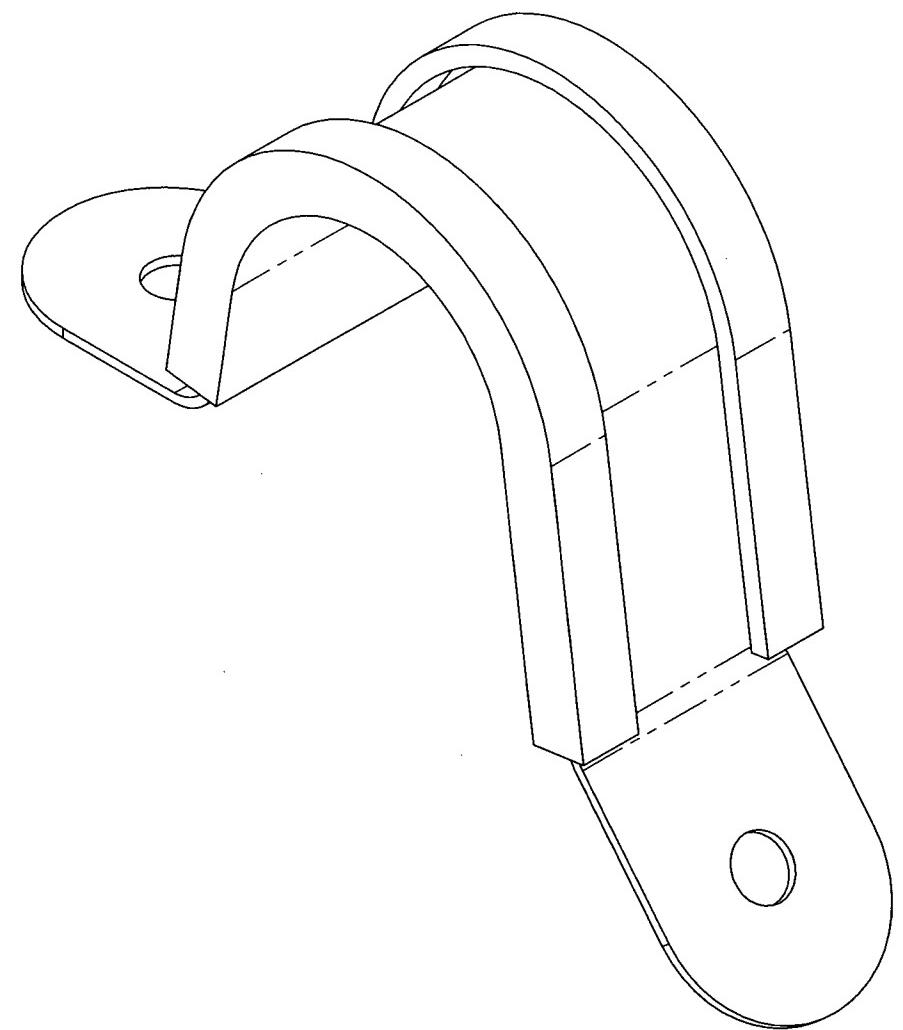
D

C

C

B

B



D3758-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
WP 08.05.26

A	New Issue	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3758	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.04.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

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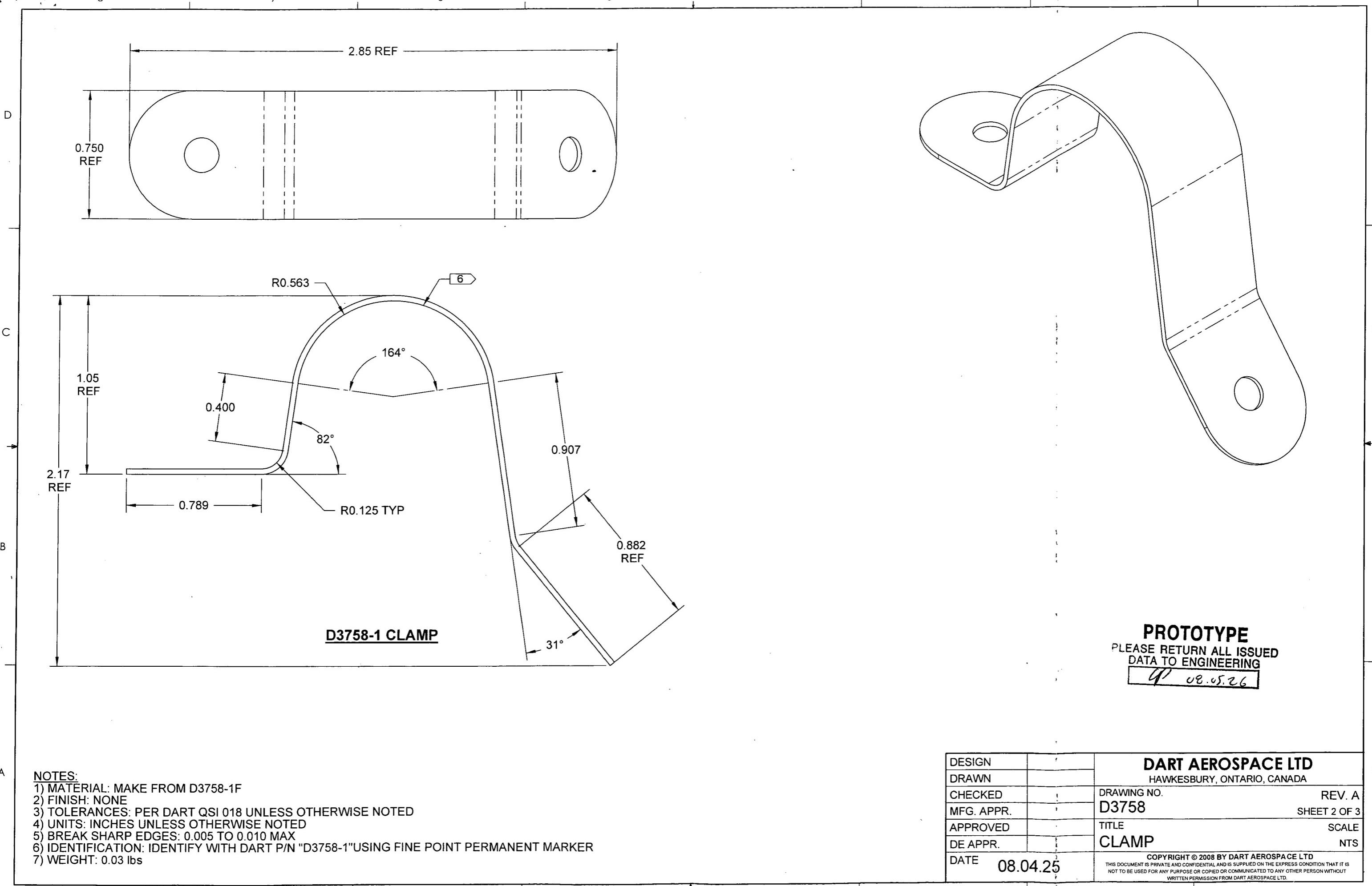
5

4

3

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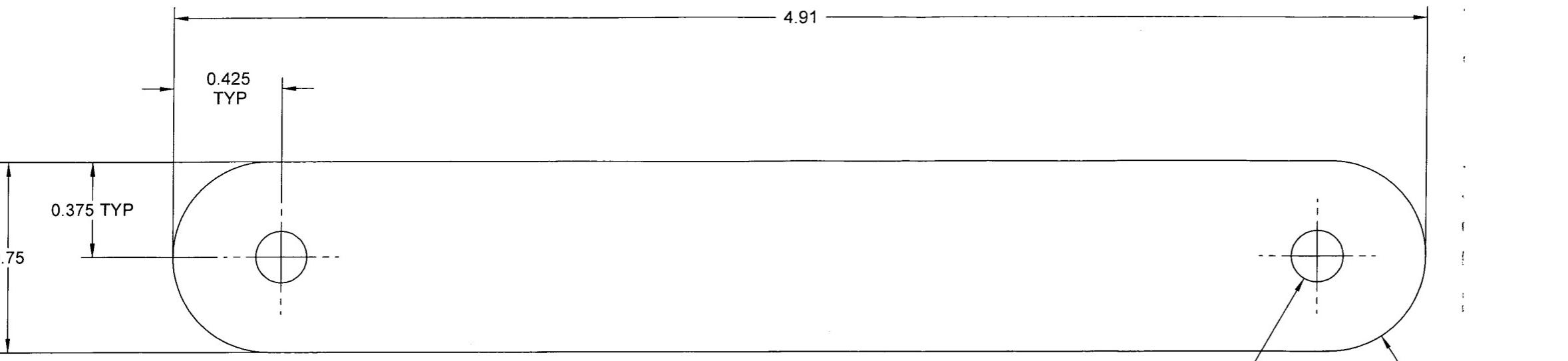
1



8 7 6 5 4 3 2 1

D

D



D3758-1F CLAMP

$\phi 0.203$ TYP
(DRILL 13/64" REF)

R0.375 (TYP)

B

B

A

A

NOTES:

- 1) MATERIAL: 304/316 SS SHEET, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
G 08.04.26

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3758
DE APPR.		SHEET 3 OF 3
DATE	08.04.25	TITLE
		CLAMP
		SCALE
		NTS
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DART AEROSPACE LTD	Work Order:	39489
Description: CLAMP	Part Number:	D3758-641
Inspection Dwg: D3758-04 Rev: DRE L.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>LB</u>	Audited by: <u>/</u>	Prototype Approval: <u>QP</u>
Date: <u>08-05-05</u>	Date: <u>08-05-05</u>	Date: <u>08-06-05</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	